



**Process: MIG (GMAW)  
Flux cored (FCAW)  
Push Pull spool gun (part no. 07NS1000)**

MALO WELDING PRODUCTS LTD.

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# **SPOOLKING 24D OWNER'S MANUAL**

[www.weldking.com](http://www.weldking.com)



**Ontario**

**Concord**

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L4K 4R2  
Tel: 1 (905) 669-4249

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## 1 Safety Precautions

Before install the welding gun, please read the operation manual carefully and understand something about the related parts such as: welder, wire feeder and cylinder valve etc, make sure that this product is installed and used correctly.

Only qualified people can operate the gun.

Turn off welding power source and disconnect input power before inspecting or installing.

The welding power source itself is not allowed to be erected in environments which involve increased electrical hazards.

Please observe the welding and cutting operation regulations to avoid accident and fire.

Always switch off the unit and close the cylinder valve when welding duty has been completed. Take care when handling gas cylinders, do not hit or heat them, secure them to prevent accidental tipping before removing.

Wear the working clothes strictly according to the labor protection, use welding gloves, a leather apron and auto darkening helmet.

Rated welding current mains the largest limitation, make sure the rated current works within correct range. Otherwise the welding gun will be damaged.

## 6 Authorized Service Center

Please go to our website [www.weldking.com](http://www.weldking.com) to fill the warranty registration form. Malo Welding Products Ltd. will not distribute or disclose customer's private information to any third party and will not send promotion material to the customer.

### Alberta

#### Calgary

**Kristian Electric Ltd.** 4215 - 64 Avenue S.E.T2C 2C8

Tel. 1 (403) 292-9111

#### Edmonton

**Kristian Electric Ltd.** 14236 - 121A Avenue T5S 4L2

Tel. 1 (780) 444-6116

#### Camrose

**A-1 Auto Electric** 4327, 41st street, T4V 2P7

Tell: 1 (780) 672-9966

#### Lethbridge

**Southern Rewind Limited** 3131 - 2nd Avenue North, T1H 0C5

Tell: 1 (403) 328-9049

### Manitoba

#### Winnipeg

**Weld Doctor Inc.** 633 Tyne Ave. R2L 1J5

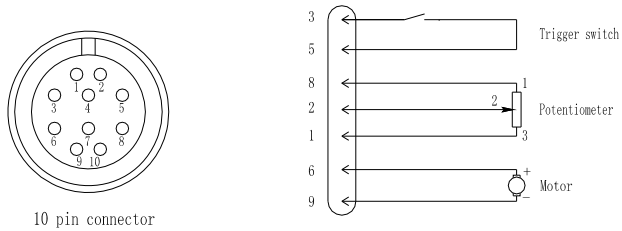
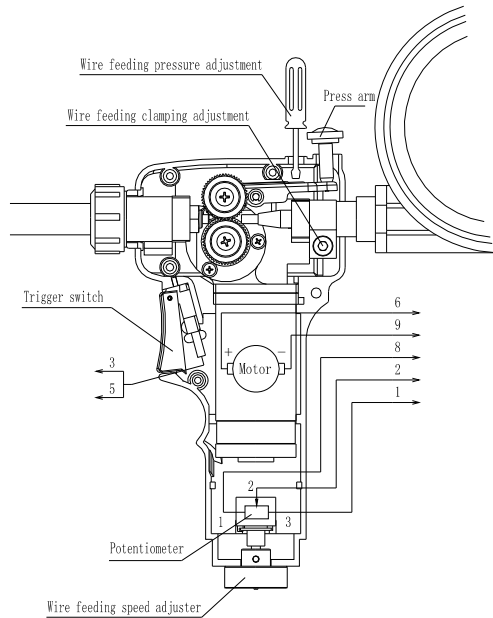
Tel: 1 (204) 6946768

### British Columbia

#### Chilliwack

**Al's Supply House Ltd.** 45732 Yale Road, Chilliwack, BC,  
V2P 2N3

Tel: 1 (604) 792-1318



Socket Pin	Function
1	Spool Gun C. C. W. Potentiometer (3)
2	Spool Gun Wiper Potentiometer (2)
3	Spool Gun Switch
4	Not used
5	Spool Gun Switch
6	Spool Gun Motor(+)
7	Not used
8	Spool Gun C. W. Potentiometer (1)
9	Spool Gun Motor(-)
10	Not used

## 2 Main specifications

Rated Welding Current	CO2	200A
	M21	160A
Duty Cycle		60%
Wire Diameter	Normal	0.6-1.2mm
	Stainless Steel	0.6-0.8mm
Wire Speed		16m/min
Spool Size		φ102mm
Motor Voltage		DC 24V
Motor Power		16W
Net Weight		5.8kg

## 3 Installation and Operation

### 3.1 Connect the welding gun with welder

Switch off welder power, make the Europe plug connect with the electrical outlet correctly and reliably. Plug the control connector into the receptacle in the machines.

### 3.2 Select correct conduct tip according to the wire used

The inner diameter of the tip is normally 0.15-0.2mm bigger than the wire diameter.

### 3.3 Adjust the wire feeding pressure

Turn the pressure adjusting screw clockwise with screwdriver, the pressure will decrease, otherwise it will increase.

### 3.4 Adjust the wire feeding speed

Turn the adjust button clockwise, the speed will increase, otherwise it will decrease.

### 3.5 Installing wire spool

Take off the spool cover, slide wire spool to its shaft, Adjust nut to make it suitable. Push wire through guides into wire feeding roll. Press the trigger, wire feeding roll make the wire into the gun tube. If you need to change the position of the wire protection cover, please make the screw loose with internal hexagon spanner; turn the wire protection cover to the position suitable then lock the screw. If you need to take off the wire protection cover, just loose the screw with internal hexagon spanner and take away from the back.

### 3.6 Adjusting welding criterion

Switch on the welder and open cylinder valve, adjust wire speed and welding voltage, gas current.

## 4 Maintenance

4.1 Every runs 300 hours, repair carbon brush of motor and clean reducer, paint No.2 Mos<sub>2</sub> lubricating grease to worm gear and bearing.

### 4.2 Normal malfunction and inspection

Malfunction	Inspection
No welding voltage	Connection of ground terminal and welding cable
	Welder
Wire feeding roll turns but do not feed wire	Adjust wire feeding pressure

Wire feeding roll does not turn	Motor conduct wire and connector
	Control wire and connector
	Control plate DC 24V power source
No protection gas	Cylinder valve, gas valve
	Flux adjuster
	Control plate

## 5 Spare Parts

Part No	Description	Spec.	Note
0711-35	Contact Tip Tweco	0.035	Standard
0711-40	Contact Tip Tweco	0.040	
0721-50	Nozzle Tweco		Standard
0751	Diffuser Tweco		Standard
07NS1004	Drive rolls for .030(0.8)-.035(0.9) steel wire. V groove		standard
07NS1005	Drive rolls for .03-.04(0.8-1.0) Al wire. U groove		
07NS1006	Drive rolls for .045(1.2) Al wire. U groove		
07NS1007	Drive rolls for .045(1.2) steel wire. V groove		
	Spanner	4mm	standard